

Work Order ID 58533

May 10, 2010 12:36:59 PM



Page 1

Item ID: D2938-2	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle RH Out, 206					
Start Date: 10/05/2010	Start Qty: 4.00		Cust Item ID:		
Required Date: 14/05/2010	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 10-5-10	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2938	Rev C								
100	HAAS CNC VERTICAL MACHINING #1	0.00				4	0		
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo Program part number and batch number. <input checked="" type="checkbox"/> 1-Inspect part number and batch number are programmed correctly. <input type="checkbox"/> 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet <input type="checkbox"/> 3-Machine Step No 2 of Folio and visually inspect as per								
110	CONVENTIONAL MILLING MACHINE	0.00				4	0		
	Mill Conv	0.00							
Conventional Milling Machine	Memo Machine Keyway and inspect per attached dimension sheet								
120	QC1- Inspect dimensions to dimension sheet	0.00				4	0		
	QC	0.00							
Quality Control	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00				4	0		
QC Quality Control	Memo	0.00		DTA 10/05/20					
140 	Chemical Conversion Coat per QSI005 4.1	0.00				4			BR 10-5-21.
HandFinish Hand Finishing	Memo	0.00							
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				4	0		
Powdercoat Powder Coating	Memo START TIME: 11:00am 11:30am FINISH TIME: 320°F	0.00		=> JH 10/05/21					

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Item ID: D2938-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 10/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-5-21 (42) SP

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

10-5-21 (42) SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/25 MF 10-5-22

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 58533



Parent Item: D2938-2



Parent Item Name: Saddle RH Out, 206

Start Date: 10/05/2010

Required Date: 14/05/2010

Comments: IPP: B ☐ 00.06.26 ☐ New DWG rev (mpp 2069) ☐ EC ☐
IPP Rev: C As per Rev C 07-03-19 JLM ☐

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	22.0000	1			

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT45

22

46410

22

4

G.A 10/05/18

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	58533
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.132	0.132	0.132	0.132		
B	0.100	0.140		0.130	0.130	0.130	0.130		
C	0.100	0.140		0.125	0.125	0.125	0.125		
D	0.210	0.230		0.221	0.221	0.221	0.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.315	0.315	0.315	0.315		
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		0.110	0.110	0.110	0.110		
O	0.540	0.560		0.551	0.541	0.545	0.551		
P	0.490	0.510		0.502	0.502	0.502	0.506		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.747	2.747	2.747	2.747		
S	0.240	0.270		0.253	0.252	0.252	0.253		
T	0.100	0.180		0.135	0.135	0.135	0.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.317	0.317	0.317	0.317		
X	1.250	1.270		1.2588	1.2595	1.260	1.260		
Y	1.565	1.585		1.5723	1.572	1.572	1.572		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	H. A
Date:	10/05/18

Audited by:	DA
Date:	10/05/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

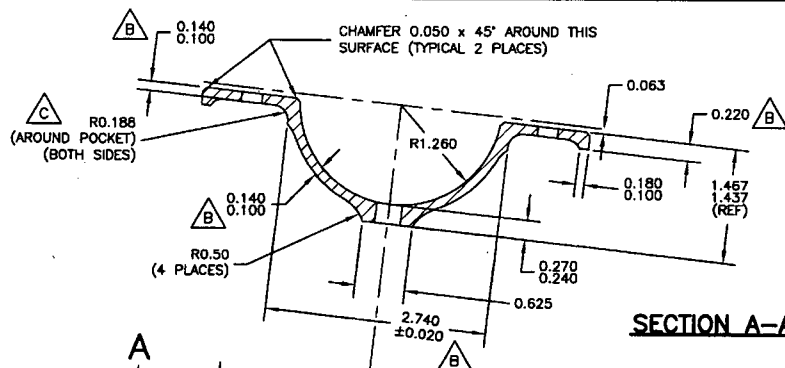
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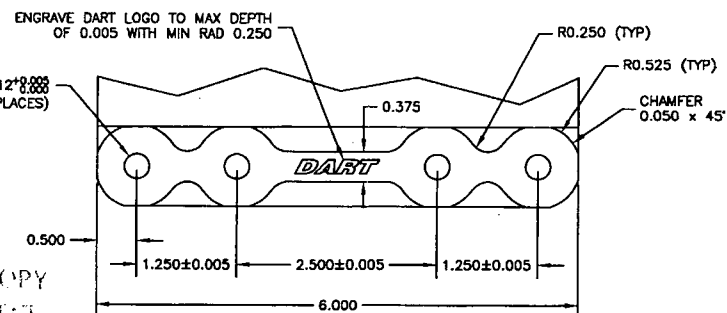
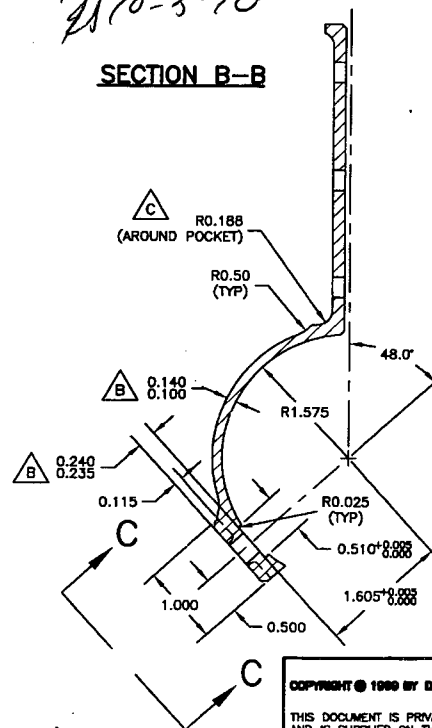
NOTE: Date & initial all entries



SECTION A-A SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58533

2810-5-10

SECTION B-B



VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		SCALE
		2:3

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO.
D2938

REV. C
SHEET 1 OF 1

TITLE
SADDLE OUTSIDE

SCALE
2:3

07.02.12

W/O:		WORK ORDER CHANGES					
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